

Date: Wednesday, 3/29/2006 6:56:59 AM
 User: Linda Lacelle

Process Sheet

SPLIT

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEB
Job Number	: 26385		
Estimate Number	: 10498		
P.O. Number	: NIA	Part Number	: D2739
This Issue	: 3/29/2006 S.O. No. : NIA	Drawing Number	: D2739 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: NIA Type : LANDING GEAR	Drawing Revision	: C
Previous Run	: 26207	Material	: NIA
Written By	: See comment below	Due Date	: 4/5/2006
Checked & Approved By	: [Signature]	Qty:	8 Um: Each
Comment	Est Rev: C 02.11.28 Reformat KJ Est Rev: D 06-03-21 As Per Rev C JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D26005108 Extrusion 'I Beam' thin



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Extrusion 'I Beam' thin

Pick:

Qty Part Number Description Batch

1 D2600-5 Web B24410 (21)

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2739 06-03-29 (21)

2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739 06-03-30 (21)

3-Use uni-bit to open holes to finish size as per Dwg D2739 06-03-30 (21)

4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends 06-03-30 (21)

5-Deburr 06-03-30 (21)

6-Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE-06-03-31 (3)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

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Part Number: D2739

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

PM 06-03-29

IT 06-03-29 (3)

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 06-03-31 (3)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

INSTALLED PM 06-03-31
on drag to location

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06-03-31

Job Completion



CU 06-03-30 (3)